

Date: Thursday, 2/14/2008 2:21:00 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HI-STEP LEG ASSEMBLY		
Job Number	37452			Part Number	D2582		
Estimate Number	10355			Drawing Number	D2582 REV B		
P.O. Number				Project Number	N/A		
This Issue	2/14/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	2/25/2008	Qty:	12
Previous Run	36710			Um:	Each		
Written By	<u>JLJ 080214</u>						
Checked & Approved By							
Comment	Est Rev:F Removed Manufacturing 05-11-07 JLM Est Rev:G Added part # to Sub 06-08-10 JLM Est Rev H New pick list 08.01.11 EC verified by: DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	37452A	STEP LEG	
		Comment: Sub-Component STEP LEG D2278 B <u>37452A</u>	<i>mf</i>
2.0	37452B	STEP SPACER	
		Comment: Sub-Component STEP SPACER D2322 B <u>37452B</u>	<i>mf</i>
3.0	37452C	STEP SPACER	
		Comment: Sub-Component STEP SPACER D2279 B <u>22585</u>	<i>mf</i>
4.0	37452D	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3720-1 <u>B 37452D</u>	<i>mf</i>
5.0	37452E	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3720-2 <u>B 37452E</u>	<i>mf</i> 08-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:00 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37452

Part Number: D2582

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
22	MS20470AD4-4	Rivet	M106654.

mf

7.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS20470AD4-5	Rivet	M104156.

mf

08-03-06

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

mf 08-03-06

(12)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (12)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA27

SE 08-03-06 12

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

(12)

Job Completion



mf 2008/3/06

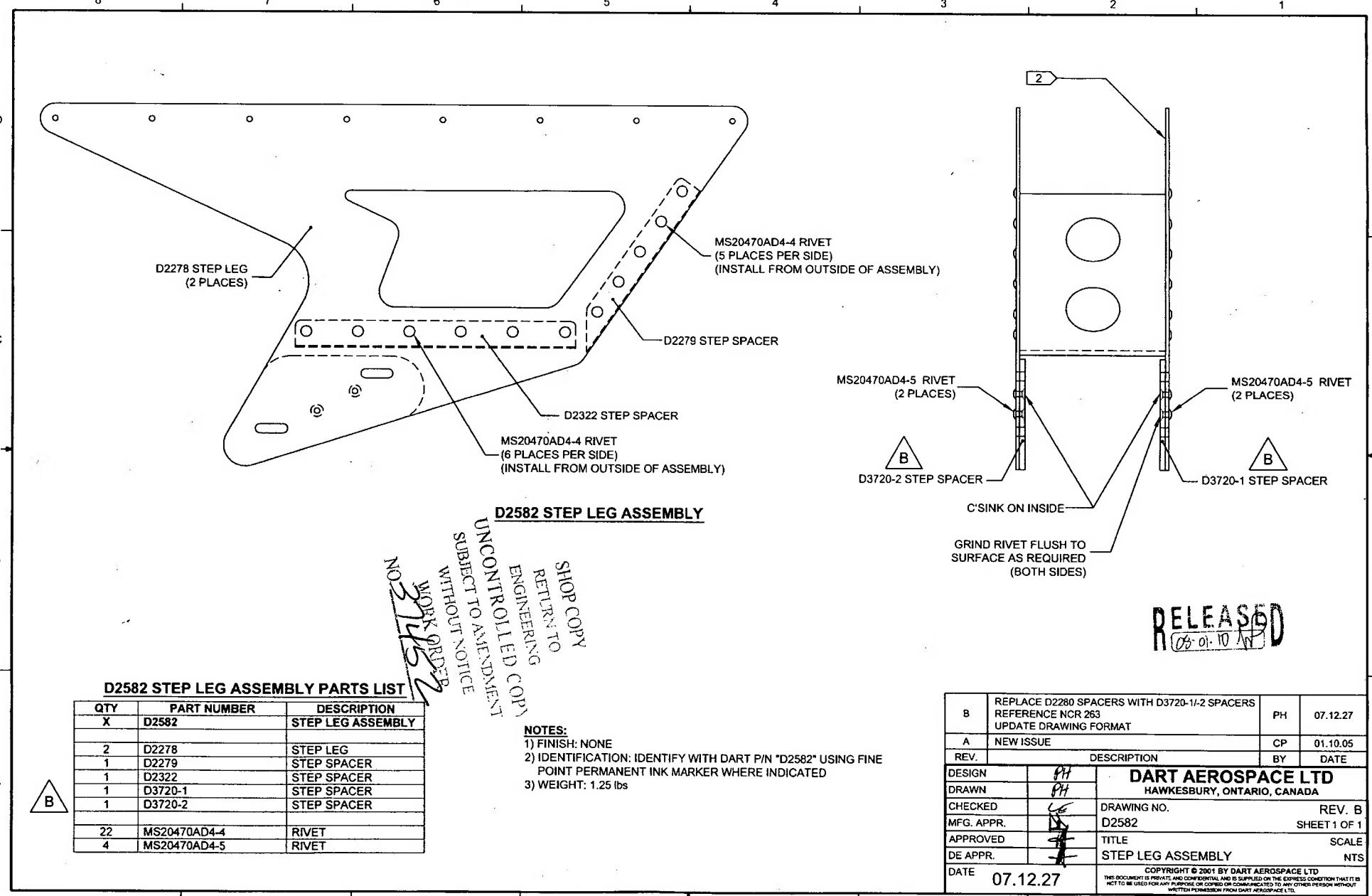
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D3232	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

## NOTES

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT			PH	07.12.27
A	NEW ISSUE			CP	01.10.05
REV.	DESCRIPTION			BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> <b>HAWKESBURY, ONTARIO, CANADA</b>			
DRAWN	<i>PH</i>	DRAWING NO.	REV. B		
CHECKED	<i>LE</i>	D2582	SHEET 1 OF 1		
MFG. APPR.	<i>DL</i>	TITLE	SCALE		
APPROVED	<i>TH</i>	STEP LEG ASSEMBLY	NTS		
DE APPR.	<i>TH</i>				
DATE	07.12.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER BY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Date: Thursday, 2/14/2008 2:21:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP LEG
Job Number	37452A		
Estimate Number	10353		
P.O. Number	:	Part Number	D2278
This Issue	2/14/2008	Drawing Number	D2278 REV F
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	F
Previous Run	36710A	Material	:
Written By	:	Due Date	2/25/2008
Checked & Approved By	:	Qty:	24
Comment	Est Rev:A New Issue 05-11-07 JLM	Um:	Each
	Est Rev:B Now 6061-T6 06-06-23 JLM		
	Est Rev C New flat pattern 08.01.11 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet  32
Comment: Qty.: 1.0306 sf(s)/Unit Total : 24.7338 sf(s) Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick (M6061T62S.080) Identify as D2278 Batch: <u>i07076</u> <u>HB 8-3-3</u>		
2.0	WATER JET	FLOW WATER JET  
Comment: FLOW WATER JET 1-Cut as per Dwg D2278 Dwg Rev: <u>F</u> <u>HB 8-3-3</u> Prog Rev: <u>F</u> <u>HB 8-3-3</u>  2-Deburr if necessary <u>HB 8-3-3</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <u>HB 8-3-3</u> 
4.0	QC8	SECOND CHECK  
		  <u>coats</u> <u>08/08/09</u> <u>t.31</u>

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 12 Date: 08/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 37452A

Part Number: D2278

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

08-03-04

(X31)

6.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

08-03-06

(31)

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

08-03-06

(31)

8.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done 03/06

Job Completion



2008/3/06

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37452A
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278	Rev: E	Page 1 of 1

PF 08.02.14

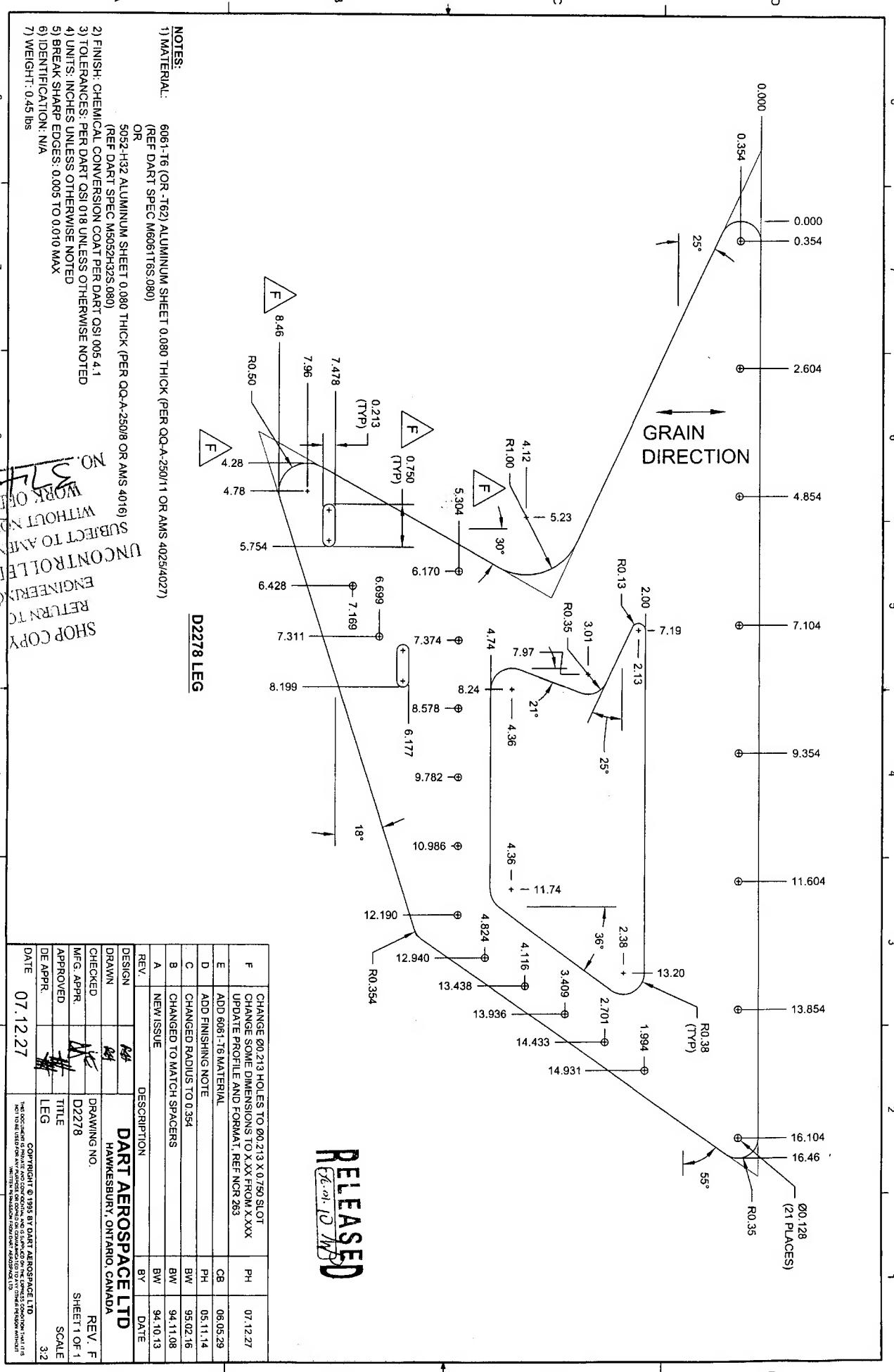
## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

f41  
08-0214

Measured by: <u>AB</u>	Audited by: <u>CD</u>	Prototype Approval: N/A
Date: <u>8-3-3</u>	Date: <u>080810f</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	



NO. 37152A  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERED  
BY [Signature]

**RELEASED**  
MAY 10 1987

**NOTES:**

1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-25011 OR AMS 4025(A027)  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H132 ALUMINUM SHEET 0.080 THICK (PER QQ-A-25018 OR AMS 4016)  
(REF DART SPEC M5052H32S.080)

2) FINISH: CHEMICAL CONVERSION COAT (PER DART QSI 005 4.1)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.45 lbs

CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT

**RELEASED**  
Ex. m. 10 May